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Schmidt et al.

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- (54) **CLAMSHELL MATERIAL FLOW AMPLIFIER**
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F15C 1/18 (2006.01)
B01F 5/06 (2006.01)

(52) **U.S. Cl.**
CPC **F15C 1/18** (2013.01); **B01F 5/064** (2013.01); **B01F 5/0614** (2013.01); **B01F 5/0651** (2013.01); **B01F 5/0659** (2013.01)

(58) **Field of Classification Search**
CPC F15C 1/18; B01F 5/0651; B01F 5/0614; B01F 5/064; B01F 5/0659
See application file for complete search history.

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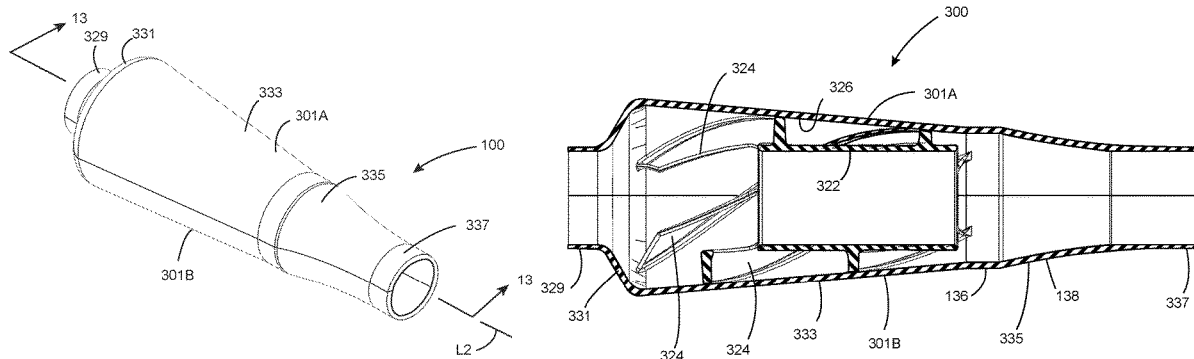
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(57) **ABSTRACT**

Material flow amplifiers as disclosed herein overcome drawbacks associated with known adverse flow conditions (e.g., surface erosion and head losses) that arise from flow of certain types of materials (e.g., fluids, slurries, particulates, flowable aggregate, and the like) through a material flow conduit. Such material flow amplifiers provide for flow of flowable material within a flow passage of a material flow conduit (e.g., a portion of a pipeline, tubing or the like) to have a cyclonic flow (i.e., vortex or swirling) profile. Advantageously, the cyclonic flow profile centralizes flow toward the central portion of the flow passage, thereby reducing magnitude of laminar flow. Such cyclonic flow profile provides a variety of other advantages as compared to a parabolic flow profile (e.g., increased flow rate, reduce inner pipeline wear, more uniform inner pipe wear, reduction in energy consumption, reduced or eliminated slugging and the like).

18 Claims, 8 Drawing Sheets



Related U.S. Application Data

(60) Provisional application No. 62/917,233, filed on Nov. 29, 2018.

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FIG. 1

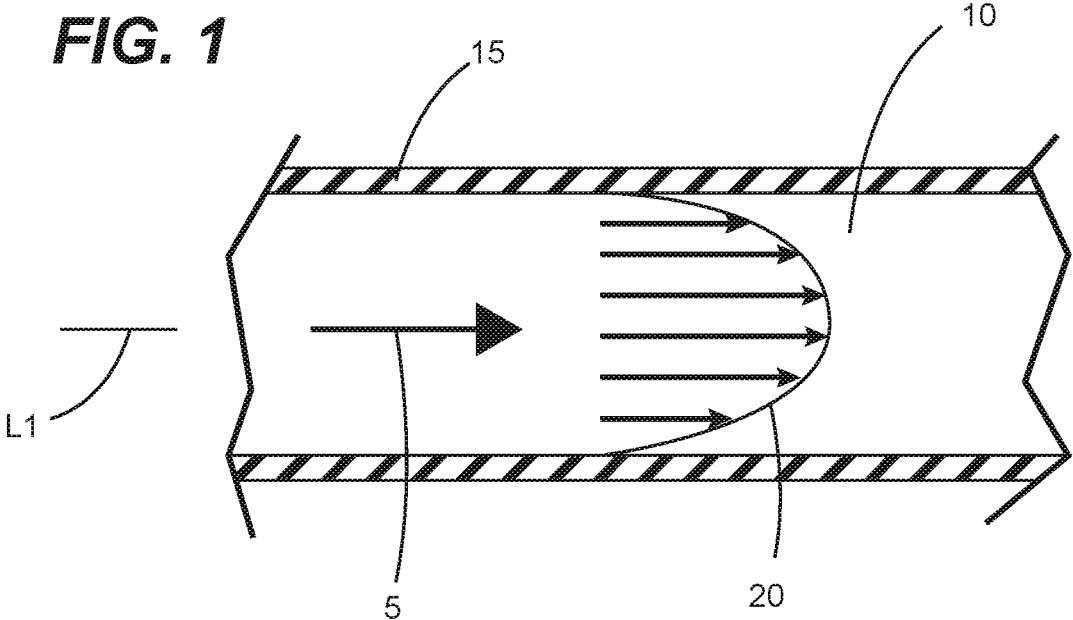
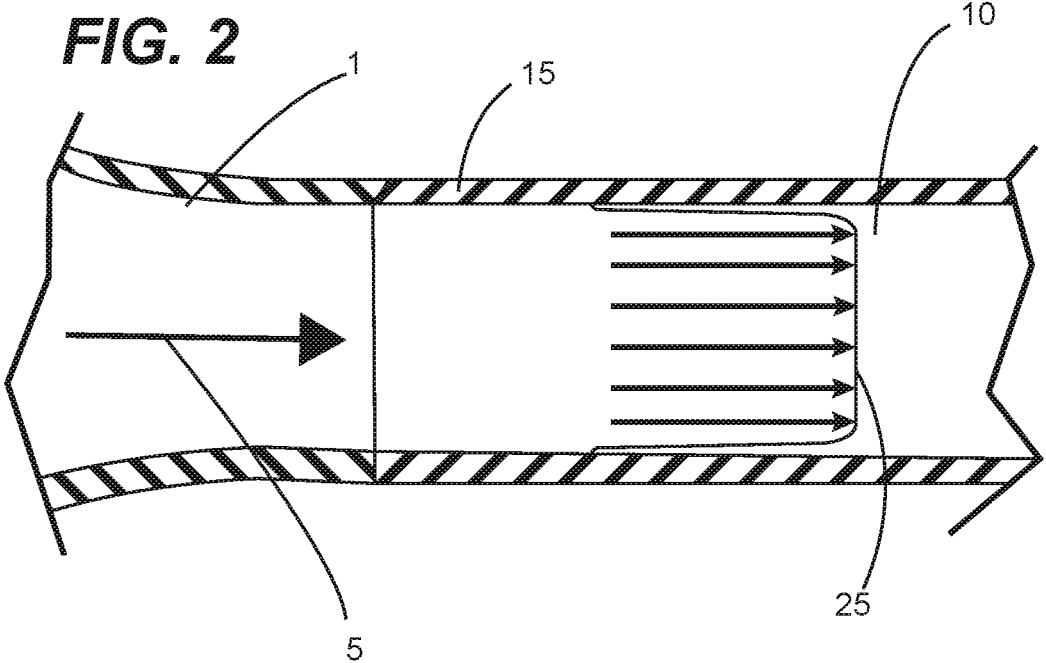


FIG. 2



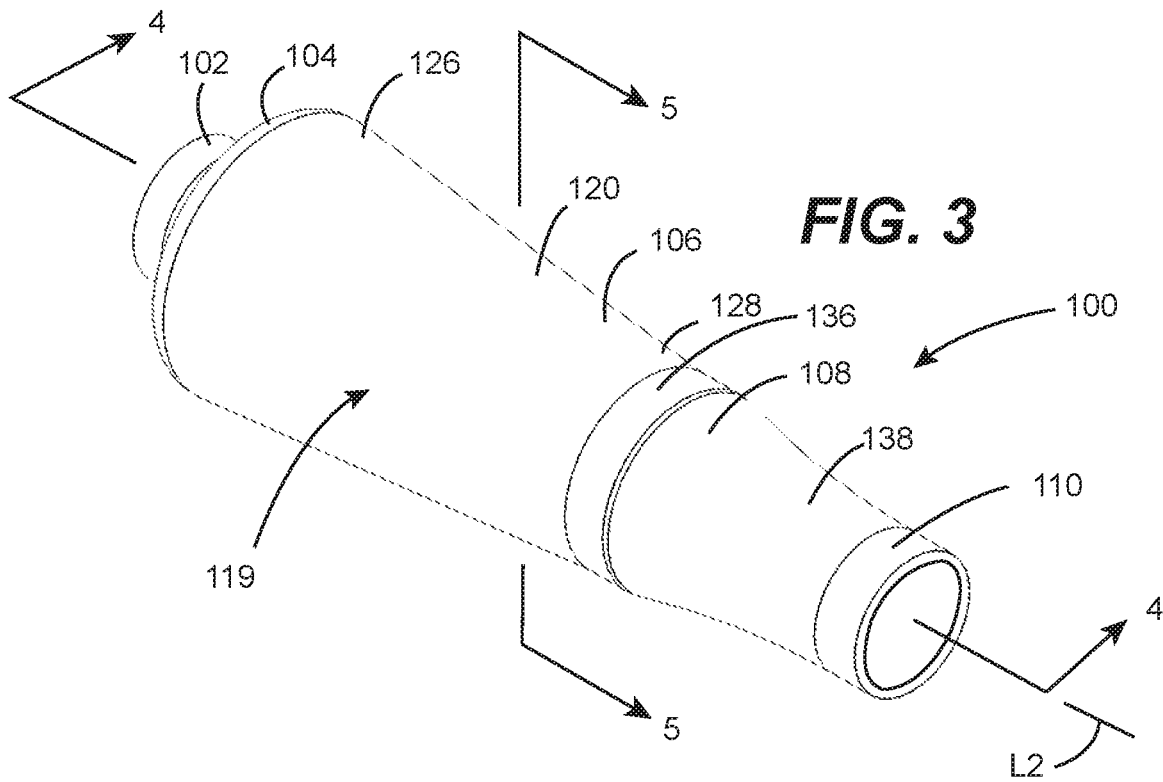


FIG. 3

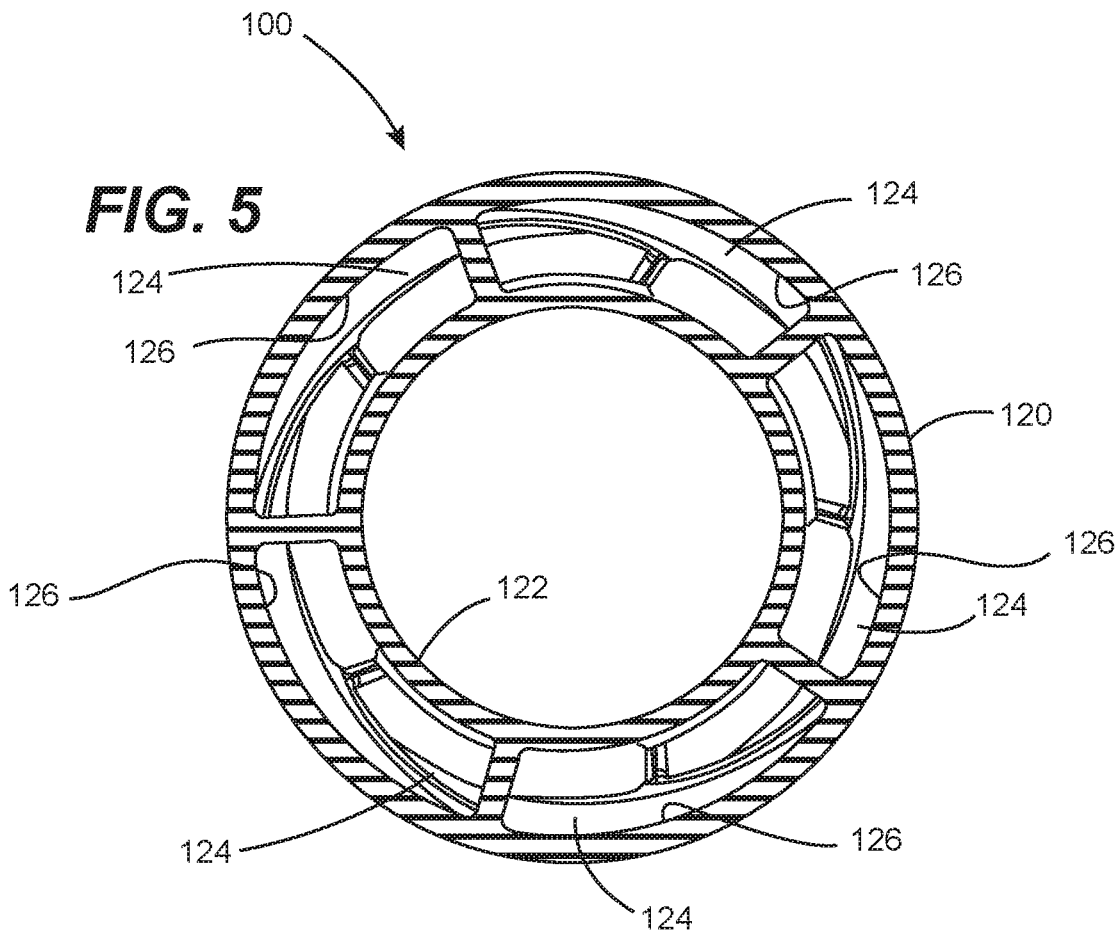


FIG. 5

FIG. 6

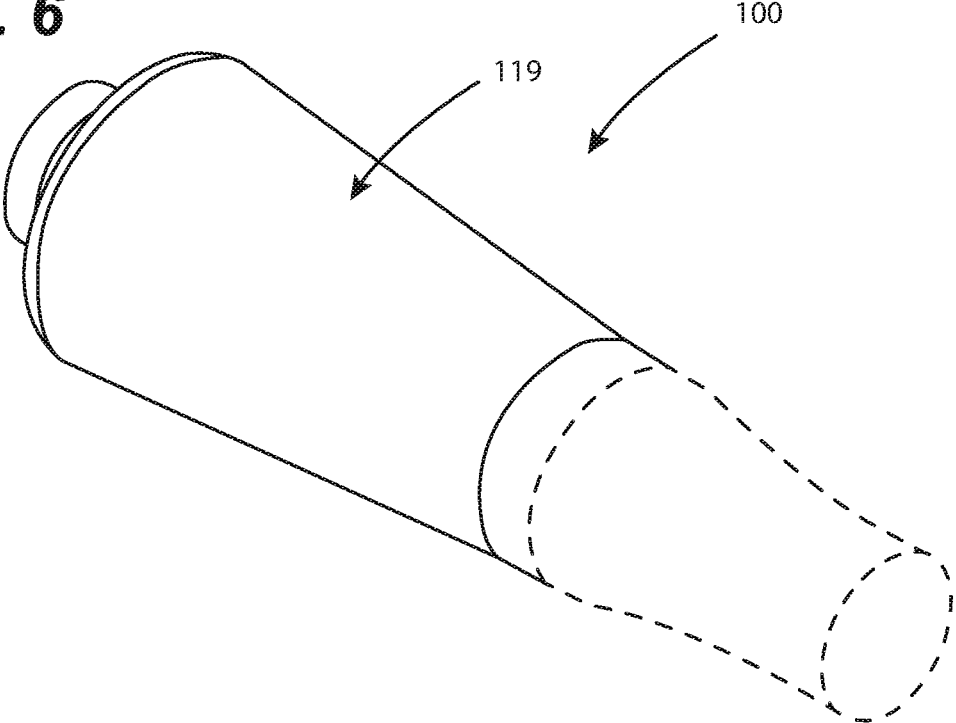


FIG. 7

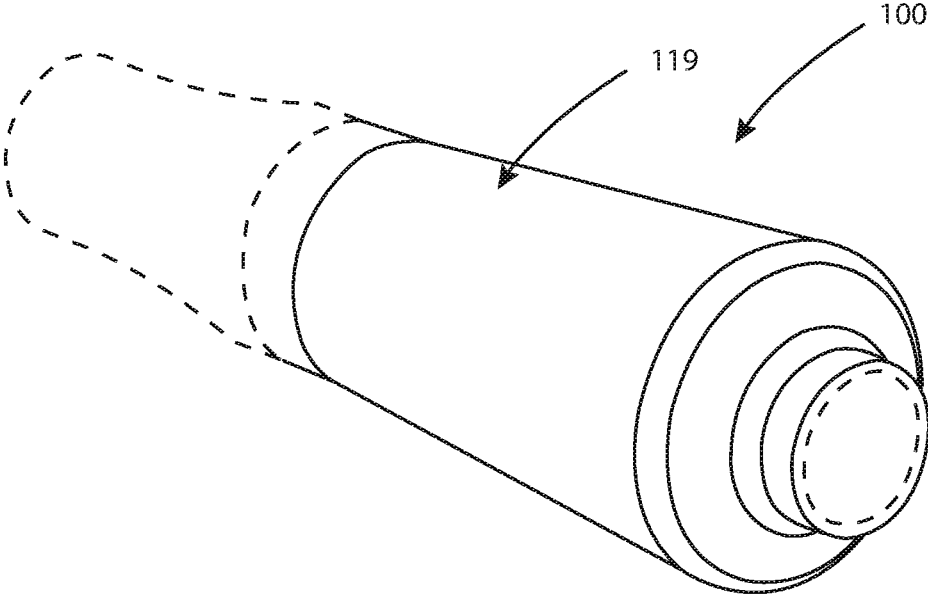


FIG. 8

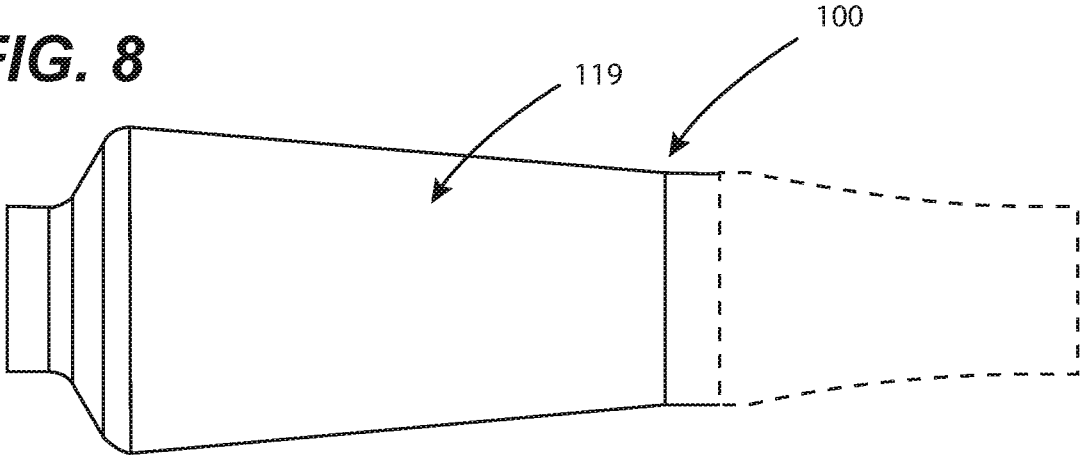


FIG. 9

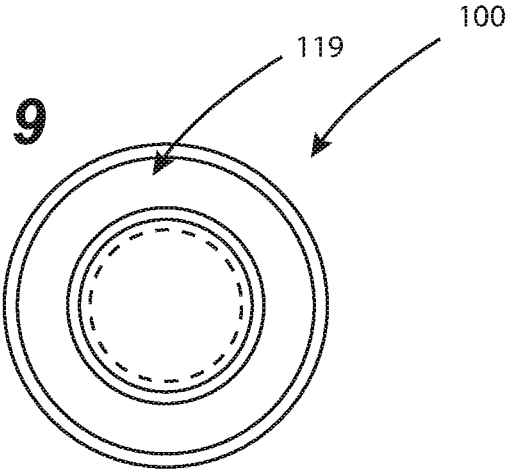


FIG. 10

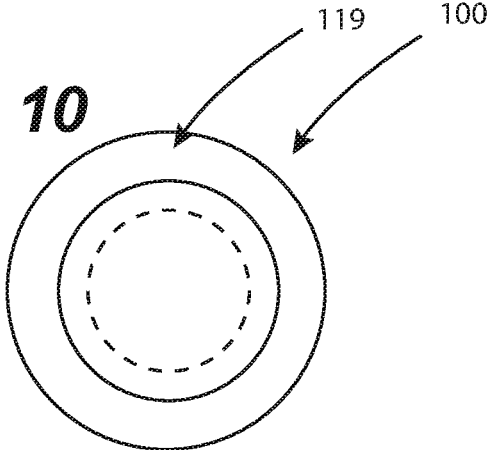
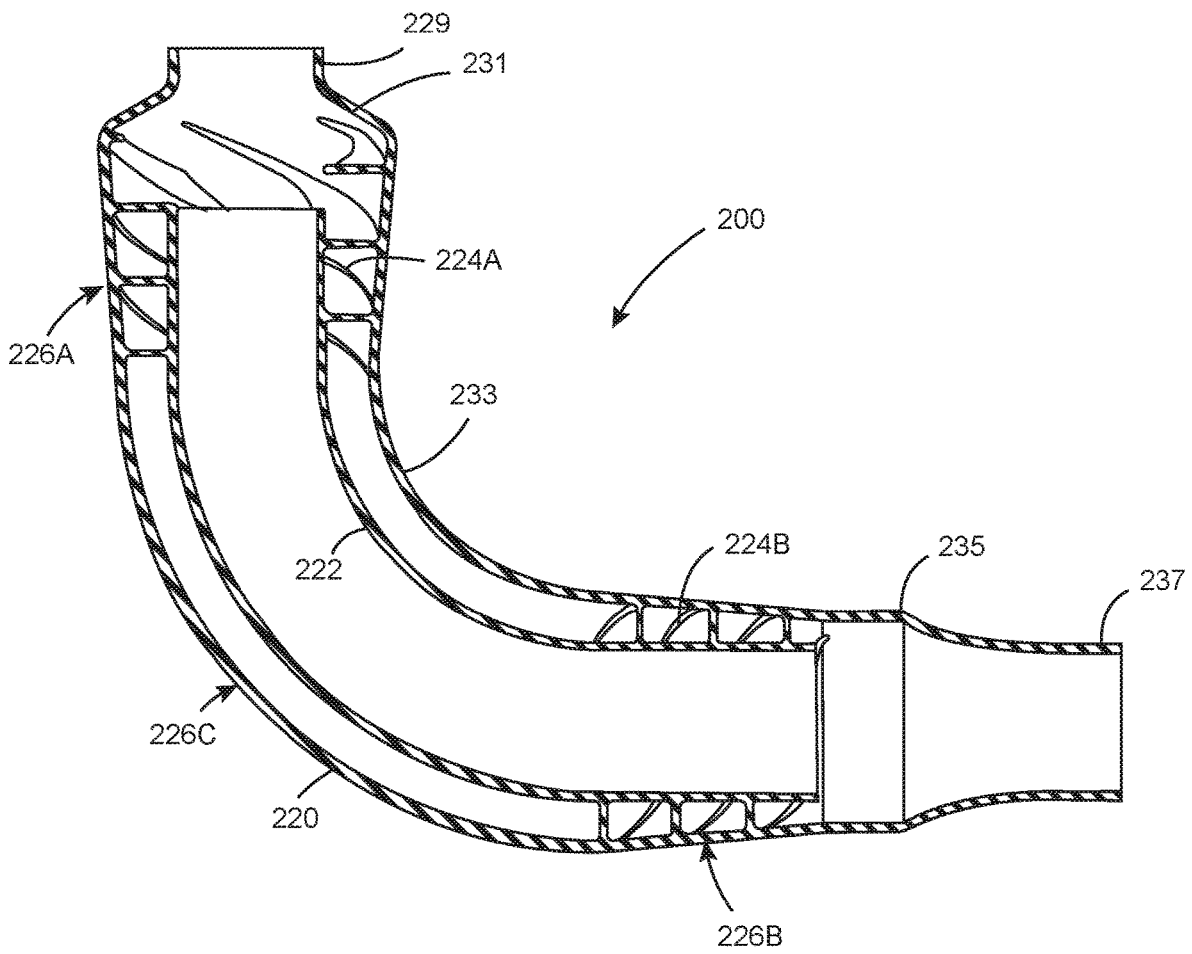


FIG. 11



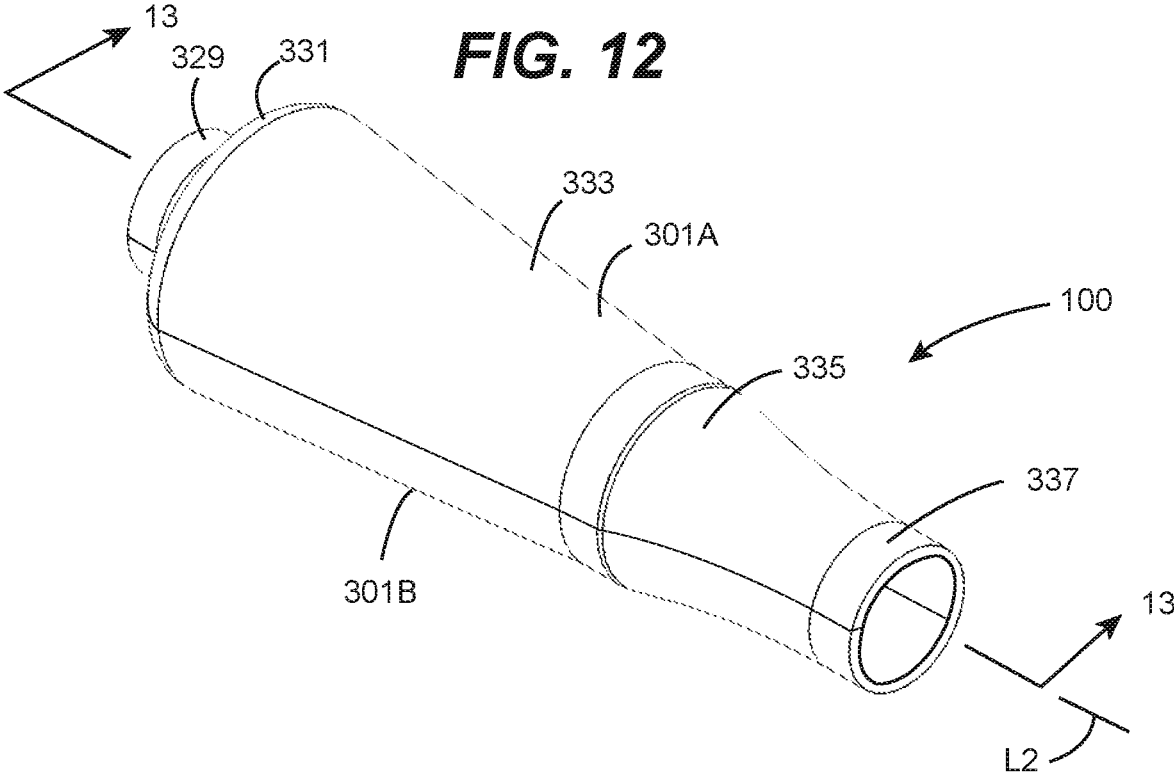
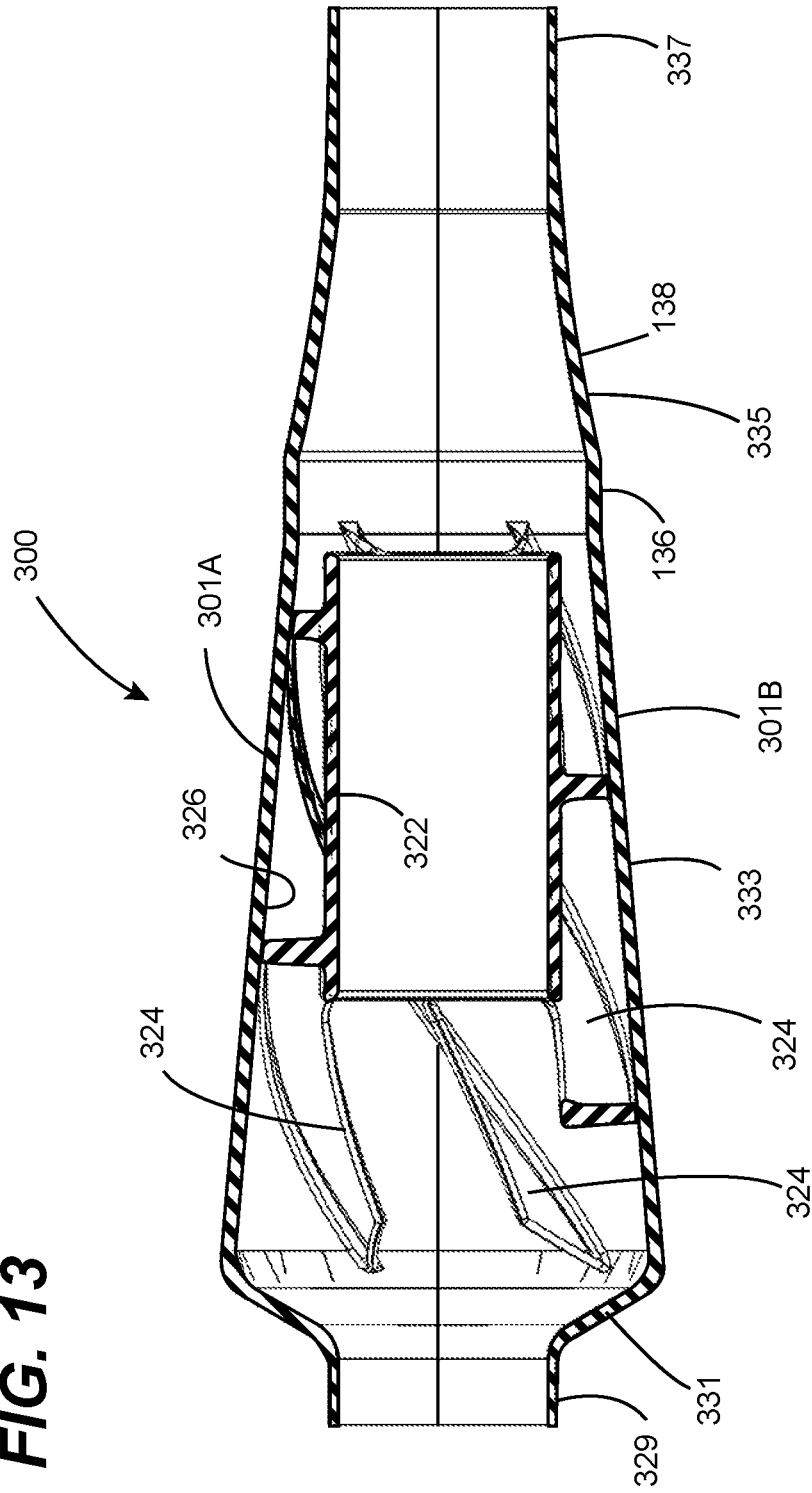


FIG. 13



CLAMSHELL MATERIAL FLOW AMPLIFIER

CROSS-REFERENCE TO RELATED APPLICATIONS

This continuation patent application claims priority from United States Non-Provisional Patent Application having Ser. No. 16/445,127, filed 18 Jun. 2019, now U.S. Pat. No. 10,458,446, entitled "MATERIAL FLOW AMPLIFIER", having a common applicant herewith and being incorporated herein in its entirety by reference. United States Non-Provisional Patent Application having Ser. No. 16/445,127 claims priority from United States Provisional Patent Application having Ser. No. 62/917,233, filed 29 Nov. 2018, entitled "MULTI-CHAMBERED VORTEX PIPELINE AMPLIFIER (FULLY PIGGABLE)", having a common applicant herewith and being incorporated herein in its entirety by reference.

FIELD OF THE DISCLOSURE

The disclosures made herein relate generally to structural devices used for transmission of flowable materials and, more particularly, to devices used for enhancing flow attributes of material within a material flow conduit such as a pipeline or a tubular flow member.

BACKGROUND

The need to flow materials (i.e., flowable material) through a material flow conduit is well known. Examples of such materials include, but are not limited to, fluids, slurries, particulates, flowable aggregate, and the like. Examples of such material flow conduit include, but are not limited to, pipes, pipelines, conduits, tubular flow members, and the like.

As shown in FIG. 1, conventional flow of flowable material **5** within a flow passage **10** of a material flow conduit **15** has a flow profile characterized by laminar flow effect (i.e., laminar flow **20**). The parabolic flow profile is a result of the laminar boundary layer along the surface of the material flow conduit **15** defining the flow passage **10**. Flowable material at the surface of the flow passage **10** exhibits considerable friction and zero flow velocity, thereby reducing velocity of the flowable material even at a considerable distance from the surface of the flow passage **10**. In association with this reduced velocity, the laminar flow effect (e.g., friction at the surface of the material flow conduit) is known to increase head loss and heating of the flowable material.

There are various well-known flow consideration that arises when abrasive material flows through a material flow conduit such as a pipeline. One such consideration is erosion (i.e., wearing) of the material flow conduit. Transport and pumping flowable material comprising abrasive contents, such as coal and sand slurries, wet sand, gravel and the like can cause especially high costs associated with component wear due to interaction between the flowable material and the surface defining the passage through which such material flows. Additionally, uneven erosion in piping systems, especially elbow fittings, is well known to lead to fitting failure or early fitting replacement, either of which is costly in material, manpower and downtime.

When fluids or flowable material passes through an elbow fitting, the change in direction creates turbulent conditions, flow separation and vortex shedding along the pipe wall at

the inside of the bend. This change in direction may also create standing eddies causing backflow conditions at points along the elbow fitting pipe walls. These conditions generally cause the elbow fitting pipe wall along the outside of the bend to erode substantially faster than the pipe wall along the inside of the bend because the flowable material impinges directly against the wall along the outside of the bend as it enters the fitting and changes direction. Additionally, due to centrifugal force, heavier solids and particulates are generally thrown to the outside wall as the flowable material changes direction and tend to continually scour the outer wall.

A similar uneven erosion effect is often experienced in long straight pipe runs. For example, the concentration of particulates of a flowable material will increase in the lower region of the fluid in long straight runs, making the bottom portion of the fluid stream more abrasive than the upper portion. Additionally, in large diameter piping systems, the weight of the flowable material is borne by the lower pipe wall portion thereby causing higher erosion rates.

Another well-known flow consideration that arises is head loss due to turbulence and flow separation in an elbow fitting. Higher pumping pressures can be utilized for mitigating this head loss resulting from such head losses. However, higher pumping pressures are generally implemented at the expense of higher energy consumption and associated cost. Additionally, implementation of higher pumping pressures often creates vibration and heating problems in the piping system.

Long radius elbow fittings and pipe sections can reduce these adverse flow considerations. However, long radius fittings require a great deal of space relative to standard (i.e., short) radius fittings. Additionally, long radius fittings still suffer accelerated erosion rates along the pipe wall along the outside of the bend because centrifugal force still causes heavier, more abrasive flowable materials to be thrown to the outer wall, and they are continually scoured by on-going flow of such flowable material.

Therefore, a device that overcomes drawbacks associated with known flow considerations that arise from flow of abrasive material flowing through a material flow conduit would be beneficial, desirable and useful.

SUMMARY OF THE DISCLOSURE

Embodiments of the present invention are directed to a device that overcomes drawbacks associated with known adverse flow conditions in pipe structures through a mechanical flow pumping device or a gravity flow system (e.g., surface erosion, head losses, fluid cavitation, heating, etc.) that arise from flow of certain types of materials (e.g., fluids, slurries, particulates, flowable aggregate, and the like) through a material flow conduit. A material flow amplifier in accordance with one or more embodiments of the present invention provides for flow of flowable material within a flow passage of a material flow conduit (e.g., a portion of a pipeline, tubing or the like) to have a cyclonic flow (i.e., vortex or swirling) profile. Advantageously, such a cyclonic flow profile centralizes flow toward the central portion of the flow passage, thereby reducing magnitude of a laminar flow. Such cyclonic flow profile provides a variety of other advantages as compared to a parabolic flow profile resulting from laminar flow (e.g., increased flow rate, reduce inner pipeline wear, more uniform inner pipe wear, reduction in energy consumption, reduced or eliminated slugging and the like).

In one or more embodiments of the present invention, a material flow amplifier comprises an amplifier body, at least one helix vane, and a centralizer tube. The amplifier body has a flow inlet structure, a flow expander, a vortex chamber, a flow mixer and a flow outlet structure all in fluid communication with each other for forming a fluid flow path therethrough. The flow expander extends from the flow inlet structure, the vortex chamber extends from the flow expander, the flow mixer extends from the vortex chamber, and the flow outlet structure extends from the flow mixer. The at least one helix vane is within the vortex chamber and extends at least intermittently (or, in some embodiments, continually) from a helix vane first end proximate the flow expander to a helix vane second end proximate the flow mixer. At least a portion of an outer edge portion of the at least one helix vane is attached to an interior surface of the amplifier body within the vortex chamber. The at least one helix vane includes a material impinging surface oriented at an angle of incidence to the flowable material entering the vortex chamber from the flow expander. The centralizer tube is within the amplifier body extending at least a portion of the length of the vortex chamber. At least a portion of an inner edge portion of the at least one helix vane is attached to an exterior surface of the centralizer tube.

In one or more embodiments of the present invention, an elbow flow amplifier comprises an amplifier body, a plurality of helix vanes and a curved centralizer tube. The amplifier body has a flow inlet structure, a flow expander, a curved vortex chamber, a flow mixer and a flow outlet structure all in fluid communication with each other for forming a fluid flow path therethrough. The flow expander extends from the flow inlet structure, the vortex chamber extends from the flow expander, the flow mixer extends from the vortex chamber and the flow outlet structure extends from the flow mixer. The plurality of helix vanes is within the vortex chamber and extends from a helix vane first end proximate the flow expander to a helix vane second end proximate the flow mixer. An outer edge portion of each of the helix vanes is attached to an interior surface of the amplifier body within the vortex chamber. Each of the helix vanes includes a material impinging surface oriented at an angle of incidence to the flowable material entering the vortex chamber from the flow expander. The curved centralizer tube is within the amplifier body and extends at least a portion of the length of the curved vortex chamber. An inner edge portion of each of the helix vanes is attached to an exterior surface of the curved centralizer tube. A centerline axis of the curved centralizer tube extends along a centerline axis of the curved vortex chamber.

In one or more embodiments of the present invention, a material flow amplifier comprises a flow inlet structure, a flow expander, a vortex flow inducer, a flow mixer, and a flow outlet structure. The flow inlet structure defines a nominal cross-sectional flow area. The flow expander includes an upstream portion thereof attached to and concentric with the downstream portion of the flow inlet structure. The flow expander includes a downstream portion thereof having a first expanded cross-sectional flow area relative to the nominal cross-sectional flow area. The vortex flow inducer comprises an exterior tubular body, a centralizer tube, and at least one at least one helical flow passage. An upstream portion of the exterior tubular body is attached to and concentric with a downstream portion of the flow expander. The centralizer tube extends at least a portion of the length of the exterior tubular body and has a cross-sectional flow area along an entire length thereof at least about the same as the nominal cross-sectional flow area. The

at least one helical flow passage extends between the exterior tubular body and the centralizer tube and extends at least partially along a length of the centralizer tube. The at least one helical flow passage includes a material impinging surface oriented at an angle of incidence to the flowable material entering the exterior tubular body from the flow expander. A centerline axis of the centralizer tube extends along a centerline axis of the exterior tubular body. The flow mixer includes an upstream portion thereof having a second expanded cross-sectional flow area attached to and concentric with a downstream portion of the exterior tubular body. The second expanded cross-sectional flow area is smaller than the first expanded cross-sectional flow area. At least the upstream portion of the flow mixer is cylindrical. The flow outlet structure includes an upstream portion thereof attached to and concentric with a downstream portion of the flow mixer. The flow outlet structure has a downstream portion with a cross-sectional flow area at least about the same as the nominal cross-sectional flow area.

In one or more embodiments, a material flow amplifier can include a plurality of helix vanes.

In one or more embodiments, the helix vane first end of one or more of the helix vanes can be located adjacent to or within the flow expander and the helix vane second end of one or more of the helix vanes can be located within the vortex chamber.

In one or more embodiments, the centralizer tube can have a cross-sectional flow area along an entire length thereof at least about the same as the nominal cross-sectional flow area.

In one or more embodiments, a length of the centralizer tube is less than a length of the vortex chamber.

In one or more embodiments, the flow inlet structure, the flow expander, the vortex chamber, the flow mixer and the flow outlet structure can all be concentric with each other.

In one or more embodiments, a centerline axis of the vortex chamber can be curved.

In one or more embodiments, the flow mixer can include a cylindrical portion extending from the vortex chamber and a convergent portion extending from the cylindrical portion.

In one or more embodiments, the convergent portion of the flow mixer can have a curved sidewall profile or a straight-taper sidewall profile.

These and other objects, embodiments, advantages and/or distinctions of the present invention will become readily apparent upon further review of the following specification, associated drawings and appended claims.

BRIEF DESCRIPTION OF THE DRAWINGS

FIG. 1 is a diagrammatic view showing laminar flow effect within a material flow conduit.

FIG. 2 is a diagrammatic view showing conversion from a laminar flow effect to rotation flow effect by a material flow amplifier configured in accordance with one or more embodiments of the present invention.

FIG. 3 is a perspective view of a straight-line material flow amplifier configured in accordance with one or more embodiments of the present invention.

FIG. 4 is a cross-sectional view taken along the line 4-4 in FIG. 3.

FIG. 5 is a cross-sectional view taken along the line 5-5 in FIG. 3.

FIG. 6 is a first perspective ornamental view of an amplifier body of the material flow amplifier (i.e., a cyclonic flow inducer) shown in FIG. 3, wherein the broken line(s)

shown is(are) included for the purpose of illustrating subject matter that can be an unclaimed portion of the ornamental design.

FIG. 7 is second perspective ornamental view of the amplifier body of the material flow amplifier shown in FIG. 3, wherein the broken line(s) shown is(are) included for the purpose of illustrating subject matter that can be an unclaimed portion of the ornamental design.

FIG. 8 is a top ornamental view of the amplifier body of the material flow amplifier shown in FIG. 3, wherein bottom, left and right ornamental views are identical to the top view, wherein the broken line(s) shown is(are) included for the purpose of illustrating subject matter that can be an unclaimed portion of the ornamental design.

FIG. 9 is a front end ornamental view of the amplifier body of the material flow amplifier shown in FIG. 3, wherein the broken line(s) shown is(are) included for the purpose of illustrating subject matter that can be an unclaimed portion of the ornamental design.

FIG. 10 is a rear end view of the amplifier body of the material flow amplifier shown in FIG. 3, wherein the broken line(s) shown is(are) included for the purpose of illustrating subject matter that can be an unclaimed portion of the ornamental design.

FIG. 11 is a cross-sectional view showing an elbow material flow amplifier configured in accordance with one or more embodiments of the present invention.

FIG. 12 is a bottom perspective view showing the guide body lock of the implanted article physical referencing apparatus of FIG. 1.

FIG. 13 is a cross-sectional view taken along the line 13-13 in FIG. 12.

DETAILED DESCRIPTION

Embodiments of the present invention are directed to material flow amplifiers that provide for increased volumetric flow rates for flowable material (e.g., fluids, slurries, particulates, flowable aggregate, and the like) and reductions in wear to material flow conduits through which flow of such flowable materials is provided. These material flow amplifiers induce a cyclonic (i.e., a vortex or swirling) flow profile that advantageously overcomes drawbacks associated with known adverse flow conditions (e.g., internal pipe wall erosion, head losses, material heating) that can arise from flow of various types of flowable materials flowing through a material flow conduit in a conventional manner (e.g., under laminar flow effect).

As discussed above in reference to FIG. 1, conventional of flowable material 5 within a flow passage 10 of a material flow conduit 15 has a flow profile characterized by laminar flow effect (i.e., laminar flow 20). However, advantageously, material flow amplifier 1 in accordance with one or more embodiments of the present invention is configured in a manner that causes conventional flow to be transformed from a flow profile characterized by laminar flow effect to a flow profile being characterized by cyclonic flow effect (i.e., cyclonic flow 25). Cyclonic flow effect is the result of rotational movement also known as whirlpool movement of the flowable material 5 about the longitudinal axis L1 of the material flow conduit 15 as generated by the material flow amplifier 1. As a person or ordinary skill in the art will understand (e.g., as depicted in FIGS. 1 and 2), cyclonic flow provides greater average flow velocity and volumetric flow than laminar flow for a given material flow conduit. Additionally, cyclonic flow mitigates adverse interaction between the surface of the material flow conduit and the

flowable material. These advantageous aspects of cyclonic flow arise from the cyclonic flow profile accelerating and centralizing flow of the flowable material toward the central portion of the flow passage 10, thereby mitigating associated adverse flow conditions and amplifying flow magnitude. The vortex generated in the amplifier also creates a siphoning effect at the inlet creating a “Push-Pull” effect of the fluid. Such cyclonic flow profile generated by the material flow amplifier 1 provides a variety of other advantages as compared to a laminar flow profile (e.g., increased flow rate, reduce inner pipeline wear, more uniform inner pipe wear, reduction in energy consumption, reduced or eliminated slugging and the like).

Generation of the cyclonic flow profile is produced by a siphoning (e.g., push-pull) effect exhibited at an upstream portion of the material flow amplifier 1. The upstream side of the flow amplifier (i.e., upstream of the flow expander) defines its suction side and the downstream side of the output side of the flow amplifier (i.e., downstream of the flow mixer) defines its suction side. The rotational flow creates a siphoning action on the suction side of the material flow amplifier, which can contribute up to about 20% or more of the total flow amplification. The siphoning effect generates material flow momentum, which is beneficial for flowable material transfer. One such beneficial aspect of flowable material transfer is that the volume of fluid transfer is greatly increased because pumping energy is not used to overcome side wall drag associated with laminar flow. In contrast, this pumping energy is advantageously used to generate greater flow velocity and volumetric flow.

As will also become apparent from the disclosures made herein, material flow amplifiers in accordance with embodiments of the present invention advantageously drive flowable material flow toward a focal point along a centerline axis of the material flow conduit. Without this focal point functionality, material flow leaving the flow amplifier would be that of a centrifuge—i.e., material being undesirably accelerated and driven toward the interior surface of the material flow conduit. In contrast, by driving the flowable material toward the centerline axis of the material flow conduit, the amount of flowable material at the interior surface of the material flow conduit is greatly reduced as compared to laminar flow or centrifuge-induced flow. Additionally, by driving flowable material flow toward the focal point of the material flow amplifier, a portion of the flowable material (i.e., generally non-rotating flowable material) becomes trapped between the inside surface of the material flow conduit (e.g., pipeline) and the exterior boundary of the rotationally flowing flowable material, thereby becoming an interface material for the rotationally flowing flowable material that serves to lower the effective coefficient of friction exhibited at the exterior boundary of the rotationally flowing flowable material (i.e., flowing of flowable material upon like material as opposed to material of the material flow conduit).

Accordingly, in view of the material flow being driven toward the centerline axis of the material flow conduit (i.e., toward the focal point of the material flow amplifier), the rotational flow profile provided for by flow amplifiers in accordance with embodiments of the present invention is propagated (e.g., because a large amount of the side wall drag is eliminated) and pipe wear is thus dramatically reduced.

To maintain the beneficial effects of cyclonic flow, one or more additional material flow amplifiers can be provided downstream of an initial material flow amplifier. The distance between amplifiers is proportional to system attributes

such as, for example, pipe size, volume of fluid desired flow rates, pipeline's layout, terrain (e.g., elevation grade) and the like. The objective of placement and configuration of the material flow amplifier is to reduce side wall drag, thereby increasing flow and utilizing the full potential of the cross-sectional flow area of a material flow conduit.

In a conventional pipe structure, internal pipe wear occurs unevenly because of the concentration of wear particles scuffing the lowest area of the pipe. In a conventional piping system heavier particle fall out and drag along the bottom of the pipe structure. The vortex action (whirlpool) condition keeps particles suspended. In all flow directional changes such as in elbow pipes, the same particles are thrown to the outside as if it were in a centrifuge. In contrast, cyclonic flow as provided for by material flow amplifiers in accordance with one or more embodiments of the present invention acts as to focus flowable material flow through more uniformly across the centerline and cross-section portion of the of the material flow conduit with less boundary layer contact. Thus, the use of one or more material flow amplifiers in accordance with one or more embodiments of the present invention can mitigate uneven wear and erosion within material flow conduit.

Referring now to FIGS. 3-10, specific aspects of a straight-line material flow amplifier **100** in accordance with one or more embodiments of the present invention are discussed. The straight-line material flow amplifier **100** includes a flow inlet structure **102**, a flow expander **104**, a vortex chamber **106**, a flow mixer **108**, and a flow outlet structure **110**. The flow inlet structure **102**, the flow expander **104**, the chamber **106**, the flow mixer **108**, and the flow outlet structure **110** are all in fluid communication with each other for forming a fluid flow path therethrough along the longitudinal axis **L2** of the straight-line material flow amplifier **100**. In preferred embodiments, as shown, the flow inlet structure **102**, the flow expander **104**, the vortex chamber **106**, the flow mixer **108**, and the flow outlet structure **110** are concentric with each other (e.g., have aligned longitudinal axes and common cross-sectional shapes).

The flow inlet structure **102** includes an upstream portion **112** and a downstream portion **114**. In preferred embodiments, the upstream portion **112** and the downstream portion **114** of the flow inlet structure **102** are of the same shape and size. However, in other embodiments, the shape and/or size of the upstream portion **112** and the downstream portion **114** of the flow inlet structure **102** can be different. The flow inlet structure **102** defines a nominal cross-sectional flow area, which can be more specifically defined by dimensional attributes of the upstream portion **112** or the downstream portion **114** of the flow inlet structure **102**. For example, where the stream portion **112** and the downstream portion **114** of the flow inlet structure **102** have the same size and shape (e.g., a round shape of a given diameter), the nominal cross-sectional flow area is a circular area of a given among of magnitude.

The flow expander **104** includes an upstream portion **116** and a downstream portion **118**. The upstream portion **116** of the flow expander **104** is attached to the downstream portion **114** of the flow inlet structure **102**. The downstream portion **118** of the flow expander **104** has a first expanded cross-sectional flow area relative to the nominal cross-sectional flow area. In preferred embodiments, the first expanded cross-sectional flow area of the flow expander **104** is established by the flow expander transitioning from a diameter at its upstream portion **116** that is approximately equal to the diameter of the downstream portion of the flow inlet struc-

ture **102** to a diameter that is greater than the diameter of the downstream portion of the flow inlet structure **102**.

Jointly, the flow inlet structure **102** and the flow expander **104** form the profile of an inverted funnel (i.e., expanding material flow as opposed to converging it). This inversed funnel profile causes flowable material moving through the flow expander **104** to decelerate thereby exhibiting decreased density. This reduction in velocity and decrease in density causes an associated increase in volume. In this respect, the flow volume is expanded as compared to the flow volume at the upstream portion **116** of the flow expander **104**.

The vortex chamber **106** includes an exterior tubular body **120**, a centralizer tube **122**, a plurality of helix vanes **124** and a plurality of helical flow passage **126**. The flow inlet structure **102**, the flow expander **104**, the exterior tubular body **120**, the flow mixer **108** and the flow outlet structure **110** jointly define an amplifier body **119**. The exterior tubular body **120** includes an upstream portion **126** and a downstream portion **128**. The upstream portion **126** of the exterior tubular body **120** is attached to the downstream portion **118** of the flow expander **104**. The centralizer tube **122** is located within the exterior tubular body **120** and preferably can have a cross-sectional flow area along an entire length thereof that is about the same as the nominal cross-sectional flow area of the flow inlet structure **102** (e.g., same nominal pipe or tube size). Each of the helix vanes **124** extends along at least a portion of a length of the exterior tubular body **120**. All or a portion of an outer edge portion of each of the helix vanes **124** is attached to the exterior tubular body **120** and all or a portion of an inner edge portion of each of the helix vanes **124** is attached to the centralizer tube **122**, thereby defining respective ones of the helical flow passage **126**. Each of the helix vanes **124** and, thus, each of the helical flow passage **126**, includes a material impinging surface **130** oriented at an angle of incidence to the flowable material entering the exterior tubular body **120** from the flow expander **104**.

The helix vanes **124** can extend approximately an entire length of the exterior tubular body **120**. In some embodiments, a helix vane first end of one or more of the helix vanes **124** can be located adjacent to or within the flow expander **104** and a helix vane second end of one or more of the helix vanes **124** can be located within the vortex chamber **106**. In preferred embodiments, the helix vane first end of all of the helix vanes **124** can be located at a position within the exterior tubular body **120** exhibiting at least about 75% of the first expanded cross-sectional flow area of an upstream portion of the exterior tubular body **120** (i.e., the upstream portion of the vortex chamber **106**) and a helix vane second end of all of the helix vanes **124** can be located within the vortex chamber **106** proximate a trailing edge of the centralizer tube **122**.

The helix vanes **124** each extend helically along a length of the vortex chamber **106**. The helix vanes **124** are preferably spaced equidistant from each other but can also be spaced apart from each other in a non-equidistant manner. In one or more embodiments, the helical pitch of each of the helix vanes **124** is such that each of the helix vanes **124** can have an angular rotation of from about 90-degrees to about 360-degrees about the interior of the vortex chamber **106** (e.g., as measured about the longitudinal axis **L2** of the straight-line material flow amplifier **100**). In one or more other embodiments, the helical pitch of each of the helix vanes **124** is such that each of the helix vanes **124** have an angular rotation of from about 120-degrees to about 270-degrees about the interior of the vortex chamber **106**. In

preferred embodiments, each of the helical flow chambers 126 exhibits a reduction in cross-sectional area along its length throughout the spiral wrap creating amplification and acceleration of the fluid. In yet other embodiments, the pitch of each of the helix vanes 124 is such that each of the helix vanes 124 can have an angular rotation in excess of about 360 degrees or in excess of about 540 degrees about the interior of the vortex chamber 106. In general, overall length of the helix vanes 124 and the length and volume of the helical flow passages 126 are proportional to the overall magnitude (i.e., strength) of the cyclonic flow.

The centralizer tube 122 extends at least a portion of the length of the exterior tubular body 120 and has a cross-sectional flow area along an entire length thereof at least about the same as the nominal cross-sectional flow area as defined by the inlet flow structure 102. In one or more embodiments, the centralizer tube 122 and the exterior tubular body 120 can have a common centerline axis, which is the longitudinal axis L2 of the straight-line material flow amplifier 100.

In a preferred embodiment, as shown in FIG. 4, the centralizer tube 122 and helix vanes 124 have respective lengths such that a leading edge of the centralizer tube 122 is spaced away from the downstream portion 116 of the flow expander 104, the helix vane first end of one or more of the helix vanes 124 is located adjacent to or within the flow expander 104 and the helix vane second end of all of the helix vanes 124 and the trailing edge of the centralizer tube 122 are located adjacent to or slightly within the flow expander 104. This relationship is desirable as it permits flowable material entering the vortex chamber 106 from the flow expander 104 to follow a path of least resistance either into the centralizer tube 122 or along the material impinging surface 130 of one of the helix vanes 124 and into the respective one of the helical flow passage 126 and permits these individual flows of flowable material to enter the flow mixer 108 with minimal mixing therebetween within the vortex chamber 106. Preferably, the exterior tubular body 120, the centralizer tube 122 and the helix vanes 124 are jointly configured (e.g., length of the vortex chamber, taper of the vortex chamber, length of the centralizer tube, location of leading edge of centralizer tube, pitch and length of helix vanes, surface area of helix vanes, and volume of material flow passages) such that at least about 65% of the flowable material entering the vortex chamber 106 flows in aggregate through the helical flow passages 126 with the remainder of such flowable material flowing through the centralizer tube 122.

Still referring to the relationship between the exterior tubular body 120, the centralizer tube 122 and the helix vanes 124, in one or more embodiments, the helix vane first end of all of the helix vanes 124 is located at a position within the exterior tubular body 120 exhibiting at least about 75% of the first expanded cross-sectional flow area of an upstream portion of the exterior tubular body 120, each of the helix vanes 124 extends along at least about 60% an entire length of the vortex chamber 106 with an angular rotation of from about 90-degrees to about 360-degrees about the interior of the exterior tubular body 120, the centralizer tube 122 has a length of at least about 40% the length of the helix vanes 124, the centralizer tube 122 has a cross-sectional flow area along an entire length thereof that is not less than the nominal cross-sectional flow area of the flow inlet structure 102, and both the centralizer tube 122 and all of the helix vanes 124 (e.g., inner edges thereof) terminate within the exterior tubular body 120. In preferred embodiments, the helix vane first end of all of the helix

vanes 124 is located at a position within the exterior tubular body 120 exhibiting at least about 90% of the first expanded cross-sectional flow area of an upstream portion of the exterior tubular body 120, each of the helix vanes 124 extends along at least about 80% an entire length of the exterior tubular body 120 with an angular rotation of from about 120-degrees to about 270-degrees about the interior of the exterior tubular body 120, the centralizer tube 122 has a length of about 50% to about 75% the length of the helix vanes 124, the centralizer tube 122 has a cross-sectional flow area along an entire length thereof that is about the same as the nominal cross-sectional flow area of the flow inlet structure 102, and both the centralizer tube 122 and all of the helix vanes 124 terminate within the exterior tubular body 120.

Thus, material flow amplifiers in accordance with one or more embodiments of the present invention advantageously provide for generation of material flow having cyclonic flow. Though use of helical helix vanes arranged (e.g., sized and equidistantly spaced) to provide helical flow passage that are enclosed (e.g., sidewalls defined by exterior tubular body, the centralizer tube and adjacent helix vanes) and that are preferably equal in size and volume, resulting cyclonic flow of flowable material flowing through a material flow amplifiers in accordance with one or more embodiments of the present invention is controlled and balanced. In contrast to material flow amplifiers that do not include enclosed helical flow passages, material flow amplifiers in accordance with one or more embodiments of the present invention exhibit negligible or no overflow or other flow interaction of flowable material from one helical flow space to another. This isolation of flow mitigates flow imbalances that can cause flow disturbances resulting in adverse flow conditions (e.g., vibrations in material flow conduit, pulsations in material flow, eddy currents in material flow, etc.), which can induce structural damage and limit material flow efficiency.

The flow mixer 108 includes an upstream portion 132 and a downstream portion 134. The upstream portion 132 of the flow mixer 108 is attached to the downstream portion 128 of the exterior tubular body 120. The upstream portion 132 of the flow mixer 108 has a second expanded cross-sectional flow area that is smaller than the first expanded cross-sectional flow area of the flow expander 104. The minimum cross-sectional flow area of the exterior tubular body 120 is generally located at the point of attachment of the upstream portion 132 of the flow mixer 108 to the downstream portion 128 of the exterior tubular body 120, whereby the second expanded cross-sectional flow area is generally the same as the minimum cross-sectional flow area of the exterior tubular body 120. Accordingly, in preferred embodiments where the exterior tubular body 120 has a round cross-sectional shape, the second expanded cross-sectional flow area being smaller than the first expanded cross-sectional flow area corresponds to the exterior tubular body 120 being conically shaped and the helical flow passages 126 being tapered along their length (i.e., wider upstream and narrower downstream).

As shown in FIGS. 3 and 4, in preferred embodiments, the flow mixer 108 preferably can include a cylindrical portion 136 that defines the upstream portion 132 of the flow mixer 108 and a convergent portion 138 that defines the downstream portion 134 of the flow mixer 108. The convergent portion 138 can have an inwardly curved sidewall profile (e.g., parabolic-shaped) or a straight-taper sidewall profile. The cylindrical portion 136 extends for a portion of the overall length of the flow mixer 108 and the convergent portion 138 can extend for a remaining portion of the overall

length of the flow mixer **108**. In some embodiments, the cylindrical portion **136** can be omitted such that the flow mixer **108** consists entirely of the convergent portion **138**.

The flow mixer **108** provides a volumetric space in which material flow through the helical flow passages **126** and the centralizer tube **122** can merge together. In contrast to material flow amplifiers with a flow mixer that does not include a cylindrical portion, the cylindrical portion **136** of the flow mixer **108** of material flow amplifiers in accordance with one or more embodiments of the present invention (e.g., straight-line material flow amplifier **100**) provides a volumetric space in which the merging flows of material from the vortex chamber **106** are able to merge prior to being subjected to convergent compression by the convergent portion **138** of the flow mixer **108**. The tapered profile of convergent portion **138** of the flow mixer **108** creates a focal point of the cyclonic flow of the flowable material. In preferred embodiments, the focal point of the cyclonic flow of the flowable material is located prior to the flow outlet structure **110**. Accordingly, in view of the disclosures made herein, a person of ordinary skill in the art will understand that the duration of strength of the cyclonic flow downstream of the material flow amplifier is defined by dimensional and structural attributes of the flow expander **104**, the vortex chamber **106** and the flow mixer **108**.

The flow outlet structure **110** includes an upstream portion **140** and a downstream portion **142**. In preferred embodiments, the upstream portion **140** and the downstream portion **142** of the flow outlet structure **110** are of the same shape and size and can have the same or about same cross-sectional flow area as the inlet flow structure **102** (e.g., the nominal cross-sectional flow area). However, in other embodiments, the shape and/or size of the upstream portion **140** and the downstream portion **142** of the flow outlet structure **110** can be different.

Material flow amplifiers in accordance with one or more embodiments of the present invention can have a vortex chamber with a centerline axis that is curved (i.e., elbow material flow amplifiers). The centerline axis of the vortex chamber and its side walls are curved and profiled in compound angles. Such curved centerline axis provides a material flow amplifier in the form commonly referred to as a “pipe elbow”. Pipe elbows are well known to have curvature or from as little as about 15-degrees from straight to as much as 90-degrees from straight. It is also well known that conventional pipe elbows exhibit unbalanced flow. As flowable material is directed around the curvature of the pipe elbow, centrifugal force pushes the flowable material toward the outside radius of the pipe elbow, thereby causing flow resistance, friction, and premature pipe wall wear. Advantageously, the structure of the elbow material flow amplifiers configured in accordance with one or more embodiments of the present invention serves to promote cyclonic flow therethrough and thus balanced fluid flow therethrough (i.e., flow uniformly along the centerline axis).

An elbow material flow amplifier **200** in accordance with an embodiment of the present invention is shown in FIG. **11**. As shown, the elbow material flow amplifier **200** has an overall construction similar to that of the straight-line material flow amplifier **100** discussed above in reference to FIGS. **3-10**. The aspects of the elbow material flow amplifier **200** that are notably different than that of the straight-line material flow amplifier **100** are discussed.

The elbow material flow amplifier **200** provides an amplifier body that includes a plurality of amplifier segments—an inlet section **229**, a flow expander section **231**, a vortex inducer section **233**, a flow mixer section **235** and a flow

outlet section **237**. Jointly, each of these sections **229-237** provides the same function as a corresponding section of the straight-line material flow amplifier **100** discussed above in reference to FIGS. **3-10**. As shown, the vortex inducer section **233** can have a first helix vane segment **224A** that extends from proximate the flow expander section **231** and terminate proximate a location where curvature of a centralizer tube **222** of the vortex inducer section **233** begins and can have a second helix vane segment **224B** that extends from proximate a location where curvature of the centralizer tube **222** of the vortex inducer section **233** ends and terminates proximate the flow mixer section **235**. An exterior tubular body **220** of the vortex inducer section **233**, the first helix vane segment **224A**, the second helix vane segment **224B** and the centralizer tube **222** can jointly define upstream helical flow passages **226A**, downstream helical flow passages **226B** and an intermediate flow passage **226C** extending therebetween. Preferably, intermediate flow passage **226C** has no vanes or other internal structure and maintains a uniform cross-sectional area along its length, thereby allowing rotational flow from within the upstream helical flow passages **226A** to continue in an unrestricted manner within the intermediate flow passage **226C**. In this respect, the helix vanes **224A**, **224B** and the helical flow passages **226A**, **226B**, **226C** extend intermittently along the length of the exterior tubular body **220**. In one or more other embodiments, a length of the intermediate flow passage **226C** can be substantially longer than shown, a length of the intermediate flow passage **226C** can be substantially shorter than shown, the intermediate flow passage **226C** can have a decreasing cross sectional area along its length, and/or the intermediate flow passage **226C** can be omitted such that one or more helical flow passages extend contiguously along at least a portion of the length of the centralizer tube **222**.

As shown, the centralizer tube **222** terminates at a location after the curvature of the centralizer tube **222** ends. Such configuration provides for the downstream helical flow passages **226B** to be linear as opposed to having curvature. The linear portion of the downstream helical flow passages **226B** (or downstream portion of contiguous helical flow passages) utilizes natural centrifuge force of material flowing through the curved portion of the vortex inducer section **233** to further promote rotational flow. In preferred embodiments, a length of such linear portion of the downstream helical flow passages **226B** (or downstream portion of contiguous helical flow passages) is at least about 10% a length of the curved portion of the centralizer tube **222** (as measure along the centerline thereof) and is preferably at least about 25% the length of the curved portion of the centralizer tube **222**.

Material flow amplifiers in accordance with embodiments of the present invention can be fabricated utilizing various known and yet to be discovered materials and fabrication techniques. Examples of useful material classes include, but are not limited to, metallic material (e.g., metal alloys), concrete (i.e., a cement-based material), and polymeric materials (e.g., plastics). Examples of useful fabrication techniques include, but are not limited to, casting, forging, welding and the like for metallic materials and casting, molding, 3-D printing and the like for polymeric materials.

In one specific implementation of a fabrication technique, as shown in FIGS. **12-13**, a material flow amplifier in accordance with one or more embodiments of the present invention can have a “clamshell” configuration (i.e., clamshell material flow amplifier **300**). As shown, the clamshell material flow amplifier **300** has an overall construction similar to that of the straight-line material flow amplifier **100**

discussed above in reference to FIGS. 3-10. The aspects of the clamshell material flow amplifier 300 that are notably different than that of the straight-line material flow amplifier 100 are discussed. It is also disclosed herein that such clamshell configuration is equally applicable to conventional material flow amplifiers (e.g., those that do not include a centralizer tube).

The clamshell material flow amplifier 300 includes opposing amplifier bodies 301A, 301B. The amplifier bodies 301A, 301B jointly define an amplifier body within which a centralizer tube 322, a plurality of helix vanes 324 and helical flow passages 326 (or a single helix vane and corresponding single helical flow passage). The amplifier body includes a plurality of amplifier segments—an inlet section 329, a flow expander section 331, a vortex inducer section 333, a flow mixer section 335 and a flow outlet section 337. Jointly, each of these sections 329-337 provides the same function as a corresponding section of the straight-line material flow amplifier 100 discussed above in reference to FIGS. 3-10.

Advantageously, the clamshell material flow amplifier 300 decouples fabrication of the amplifier body from internal components disposed therein. The amplifier bodies 301A, 301B can be fabricated by any suitable fabrication technique (e.g., casting, forging, hydroforming, machining, 3-D printing or the like) and from any suitable material (e.g., metallic material, polymeric material ceramic material or the like). Separately, from any suitable material (e.g., metallic material, polymeric material ceramic material or the like), each of the internal components can be independently fabricated using a respective suitable fabrication technique (e.g., shaping, casting, forging, hydro-forming, machining, 3-D printing or the like) and then assembled (e.g., via welding, bonding or the like) to form an vortex chamber insert 339 comprising the centralizer tube 322 and the helix vanes 324 to produce a vortex chamber insert 339. Alternatively, the vortex chamber insert 339 can be formed in a one-piece manner using by any suitable fabrication technique (e.g., casting, forging, hydroforming, machining, 3-D printing or the like) and from any suitable material (e.g., metallic material, polymeric material ceramic material or the like).

The vortex chamber insert 339 is disposed within an interior space of a first one of the amplifier bodies (e.g., amplifier body 301A) and a second one of the amplifier bodies (e.g., amplifier body 301B) is then placed into mating engagement with the first one of the amplifier bodies. Thus, the internal configuration of the clamshell material flow amplifier 300 can be generally the same as a material flow amplifier having a one-piece construction (e.g., cast construction) as shown and discussed above in reference to the straight-line material flow amplifier 100 of FIGS. 3-10. The amplifier bodies 301A, 301B can then be permanently attached to each other such as by, for example, welding, ultrasonic bonding, adhesive, or the like. Optionally, to prevent or limit relative movement therebetween, the vortex chamber insert 339 can be secured to at least one of the amplifier bodies 301A, 301B by a suitable technique (e.g., the same technique as used to attach the amplifier bodies to each other. In one or more embodiments, all or a portion of an outer edge of one or more of the helix vanes 324 can be attached to at least one of the amplifier bodies 301A, 301B (e.g., via continuous or tack welding directly or through access windows in the In yet another fabrication approach, all or segments of each of the helix vanes 324 can be formed in conjunction with a respective one of the amplifier bodies 301A, 301B and the centralizer tube placed within a cen-

tralizer tube receiving space defined by the helix vane(s) after engaging the amplifier bodies 301A, 301B with each other. All or a portion of an inner edge of one or more of the helix vanes 324 can be attached to the centralizer tube 322 (e.g., via continuous or tack welding, via bonding material such as adhesive, or the like).

Discussed now are various advantageous aspects of material flow amplifiers in accordance with embodiments of the present invention. One such advantageous aspect is that the incorporation of the centralizer tube and resulting helical flow passages provide for cyclonic flow. Such cyclonic flow is characterized by a “top end” or head that is generated by the flow expander and upstream portion of the vortex chamber and by omnidirectional flow (i.e., generally equal flow in all directions perpendicular to the axis of rotation). Each of the helical flow passages then uses the kinetic energy (i.e., energy from motion) and the flow’s velocity to generate several stream vanes of material flow (i.e., helical low streams) that unite in the flow mixer with each other and with the material flow of a centralized flow stream (i.e., flow of the centralizer tube). These material flows are then focused by the flow mixer to the centerline of the material flow amplifier, thereby forming the “tail end” of the cyclonic flow. Beneficially, the flow mixer further enhances cyclonic flow and distributes an even (i.e., balanced) cyclonic flow profile about the centerline of the material flow amplifier. Advantageously, inner sidewall conditions of material flow conduit (e.g., pipeline) downstream of a material flow amplifier has a negligible effect on the cyclonic flow. Although there is a great deal of energy loss from a fluid going through certain disruptive material flow attributes of material flow conduits (e.g., a valve, fitting, or turbulence created going from passing fluid from one pipe size to another), cyclonic flow mitigates energy loss from these disruptive material flow attributes of material flow conduits by providing for concentration of material flow along the centerline of material flow conduit downstream of the material flow amplifier thereby reducing sidewall drag and flow resistance.

Another advantageous aspect of material flow amplifiers in accordance with one or more embodiments of the present invention is providing for “soft reverse flow”. With such soft reverse flow, if there is ever a back flow surge in a system comprising one or more material flow amplifiers in accordance with one or more embodiments of the present invention, the material flow amplifier serves to reduce the back-flow (i.e., flow in the upstream direction) by at least about 50% as compared to the material flow amplifier being absent. Such soft reverse flow beneficially does not fully inhibit backflow, which would create a shock wave that is harmful to the structures of the material flow conduit, and to the pumping devices. In a gravity flow system this is especially beneficial where tide water or flooding could reverse flow in a conventional pipeline system. More specifically, in a reverse flow scenario, flowable material enters the helical flow passages from the flow mixer and then dead heads into the ‘funnel’ of the flow expander, which creates a controlled flow blockage (i.e., controlled funnel flow). In this regard, soft reverse flow is enabled by inclusion of material flow passages defined between the exterior tubular body and the centralizer tube.

Still another advantageous aspect of material flow amplifiers in accordance with embodiments of the present invention is that they are fully “piggable”, as required by the certified in accordance the American Petroleum Institute API-570 inspection process. The oil and petroleum industry require components of pipeline structures to be piggable,

which is a process that includes but is not limited to cleaning and inspection of the pipeline interior by deploying a “pigging device” that travels within the pipeline. To this end, material flow amplifiers in accordance with embodiments of the present invention permit the pigging device to travel non-obtrusively therethrough regardless of the types of sections that the pipeline includes (e.g., straight line, short radius elbows, long radius elbows, “Y” fittings, laterals, ellipse, and semi-ellipse cross sections of the pipeline).

The pigging device has an elongated body with a perimeter seal at each of its ends. The perimeter seals have a size whereby they maintain engagement with an inside diameter of a material flow conduit (e.g., pipeline) to support a pressure drop across the length of the pigging device. It is this pressure drop that serves to propel the pigging device along then length of the material flow conduit. This being the case, material flow amplifiers in accordance with embodiments of the present invention are configured to maintain engagement between at least one of the perimeter seals and the inside diameter of a material flow conduit and/or material flow amplifier. More specifically, the length of the centralizer tube of material flow amplifiers in accordance with embodiments of the present invention has a length that provides for such seal with the pigging device as it enters and leaves the material flow amplifier. As the pigging device passes through the material flow amplifier, at least one of the perimeter seals is either within portion of the material flow conduit upstream or downstream of the material flow amplifier or is within the centralizer tube. In some embodiments, the flow inlet structure and/or flow outlet structure can be configured to provide for such seal with the pigging device as it enters and/or leaves the material flow amplifier.

Material flow amplifiers in accordance with embodiments of the present invention can be fitted with flow monitor that can be viewed remotely. Regardless of whether the material flow amplifier is subsurface or above ground, the flow monitor can include one or more monitoring devices (e.g., each mounted within a respective portion of an amplifier body of the material flow amplifier) and data can be provided therefrom for continuous viewing.

Material flow amplifiers in accordance with embodiments of the present invention are useful in a variety of pipeline components such as, for example, straight-line components, elbow components, reducing laterals, tees and the like. Material flow amplifiers in accordance with embodiments of the present invention can be installed as a fitting, retrofitted to a section of pipe, or installed into a working pipeline in sections. Material flow amplifiers in accordance with embodiments of the present invention can be used in any right-hand or left-hand flow angles which also includes vertical up and vertical down applications. Material flow amplifiers in accordance with embodiments of the present invention can be used for a variety of flowable materials (e.g., fluid, liquid, slurry and the like) and in transfer systems of a variety of sizes (e.g., from about 2" (5.08 cm) to about 16' (4.877 meters) or more in diameter).

Although the invention has been described with reference to several exemplary embodiments, it is understood that the words that have been used are words of description and illustration, rather than words of limitation. Changes may be made within the purview of the appended claims, as presently stated and as amended, without departing from the scope and spirit of the invention in all its aspects. Although the invention has been described with reference to particular means, materials and embodiments, the invention is not intended to be limited to the particulars disclosed; rather, the invention extends to all functionally equivalent technolo-

gies, structures, methods and uses such as are within the scope of the appended claims.

What is claimed is:

1. A material flow amplifier, comprising:

opposing amplifier bodies each having a profile that jointly defines an amplifier body having a flow expander section, a vortex inducer section and a flow mixer, wherein the vortex inducer section extends from a downstream end of the flow expander section and the flow mixer extends from a downstream end of the vortex inducer section; and

a vortex chamber insert within an interior space of the vortex inducer section, wherein the vortex chamber insert includes a plurality of helix vanes and a centralizer tube, wherein the helix vanes extend between the centralizer tube and walls of the amplifier body jointly defining the vortex inducer section thereby defining a plurality of helical flow passages extending therebetween, wherein the centralizer tube terminates proximate an upstream end of the flow mixer; and wherein a length of the centralizer tube is less than a length of the vortex inducer section.

2. The material flow amplifier of claim 1 wherein:

at least a portion of an inner edge portion of one or more of the helix vanes is attached to the centralizer tube; and at least a portion of an outer edge portion of one or more of the helix vanes is attached to the amplifier body.

3. The material flow amplifier of claim 1 wherein:

the opposing amplifier bodies include at least a first amplifier body and a second amplifier body; and the first and second amplifier bodies are engaged with each along adjacent edges thereof.

4. The material flow amplifier of claim 1 wherein the opposing amplifier bodies jointly define at least one of a flow inlet portion extending from the flow expander section and the flow mixer extending from the vortex inducer section.

5. The material flow amplifier of claim 4 wherein an inside diameter of the flow inlet portion, an inside diameter of the centralizer tube and an inside diameter of a downstream end of the flow mixer are approximately the same.

6. The material flow amplifier of claim 1 wherein the vortex chamber insert has a one-piece construction.

7. The material flow amplifier of claim 6 wherein at least a portion of an outer edge portion of one or more of the helix vanes is attached to the amplifier body.

8. The material flow amplifier of claim 1 wherein:

the vortex inducer section is tapered from a first expanded cross-sectional area proximate the flow expander section to a second expanded cross-sectional area proximate a downstream end of the vortex inducer section; and

the first expanded cross-sectional area is greater than the second expanded cross-sectional area.

9. The material flow amplifier of claim 1 wherein a helix vane first end of one or more of the helix vanes is located at a position between the flow expander section and an upstream end of the centralizer tube.

10. The material flow amplifier of claim 9 wherein a helix vane second end of all of the helix vanes is located within the vortex inducer section.

11. The material flow amplifier of claim 10 wherein the centralizer tube terminates proximate the flow mixer.

12. The material flow amplifier of claim 1 wherein:

an upstream portion of the amplifier body has a first expanded cross-sectional flow area; and

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a downstream portion of the amplifier body has a second expanded cross-sectional flow area smaller than the first expanded cross-sectional flow area.

13. The material flow amplifier of claim 1 wherein the flow mixer includes a cylindrical portion.

14. The material flow amplifier of claim 13 wherein: the flow mixer includes a convergent portion extending from the cylindrical portion; the cylindrical portion extends from a downstream end of the vortex inducer section.

15. A method of fabricating a material flow amplifier, comprising:

providing opposing amplifier bodies each having a profile that jointly defines an amplifier body having a flow expander section and a vortex inducer section, wherein an upstream end of the vortex inducer section extends from a downstream end of the flow expander section;

placing a vortex chamber insert within a portion of a first one of the opposing amplifier bodies that defines a respective portion of the vortex inducer section of the amplifier body, wherein the vortex chamber insert includes a plurality of helix vanes and a centralizer tube;

mating a second one of the opposing amplifier bodies with the first one of the opposing amplifier bodies whereby the vortex chamber insert is located within the vortex inducer section, wherein the helix vanes extend between the centralizer tube and walls of the amplifier body jointly defining the vortex inducer section of the amplifier body to provide a plurality of helical flow passages extending therebetween; and

attaching one or more of the helix vanes to at least one of the opposing amplifier bodies after mating the second one of the opposing amplifier bodies with the first one of the opposing amplifier bodies.

16. The method of claim 15 wherein:

providing the vortex chamber insert includes providing a one-piece construction vortex chamber insert; and

placing the vortex chamber insert within the portion of the first one of the opposing amplifier bodies that defines the respective portion of the vortex inducer section of the amplifier body includes placing the one-piece con-

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struction vortex chamber insert within the portion of the first one of the opposing amplifier bodies that defines the respective portion of the vortex inducer section of the amplifier body.

17. A material flow amplifier made by a process of:

providing opposing amplifier bodies each having a profile that jointly defines an amplifier body having a flow expander section and a vortex inducer section, wherein an upstream end of the vortex inducer section extends from a downstream end of the flow expander section;

providing a vortex chamber insert including a plurality of helix vanes and a centralizer tube;

placing the vortex chamber insert within a portion of a first one of the opposing amplifier bodies that defines a respective portion of the vortex inducer section of the amplifier body, wherein the vortex chamber insert includes a plurality of helix vanes and a centralizer tube;

mating a second one of the opposing amplifier bodies with the first one of the opposing amplifier bodies whereby the vortex chamber insert is jointly located within the vortex inducer section, wherein the helix vanes extend between the centralizer tube and walls of the amplifier body jointly defining the vortex inducer section to provide a plurality of helical flow passages extending therebetween; and

attaching one or more of the helix vanes to at least one of the opposing amplifier bodies after mating the second one of the opposing amplifier bodies with the first one of the opposing amplifier bodies.

18. The process of claim 17 wherein:

providing the vortex chamber insert includes providing a one-piece construction vortex chamber insert; and

placing the vortex chamber insert within the portion of the first one of the opposing amplifier bodies that defines the respective portion of the vortex inducer section of the amplifier body includes placing the one-piece construction vortex chamber insert within the portion of the first one of the opposing amplifier bodies that defines the respective portion of the vortex inducer section of the amplifier body.

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